

Work Order ID 84163

84163

Page 1

May-07-12 8:42:35 AM

Item ID: D2873-045

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Nut Plate Assembly

Stop ***NS2***

Start Date: 07/05/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 21/05/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12/05/07

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								
100		0.00							
100	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 1.000" x 0.375" x 2.700" long								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev <u>A</u> F1819 Folio Rev <u>A</u>								
120		0.00							
120	QC2- Inspect parts off machine FAI/FA!B								
QC	Memo	0.00							
Quality Control									

FK 12/05/12

40

FK 12/05/14

40

PO 12/05/15

FK 12/05/14

40

PO 12/05/15

W/O: 84163		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2873-045 PAR #: _____ Fault Category: Marking NCR: Yes No DQA: Not Date: 2013/02/01
 Resolution: _____ Disposition: Scrap QA: N/C Closed: CK Date: _____

NCR: 13.2246		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/18/29	110	Holes are drilled more than 0.010" off-center on Qty (21) LC	DAS 16 9-83 QJ2042 12/09/04	SCRAP QP 12/18/29 Qty + 21 pcs NO Reverts	FK 13/01/15	13/01/15	DAS 16 2-3 QJ2042 12/09/04	DAS 16 2-3 12/09/04

30.02
+21
30.02
600.40
630.42

NOTE: Date & initial all entries

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Item ID: D2873-045

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Nut Plate Assembly

Start Date: 07/05/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 21/05/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

only 12/05/07

20

12/05/07

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

140

20x

3/01/16

Small Fab

Memo

0.00

Small Fab

1-Deburr 2- C'sink as per Dwg D2873

150

QC5- Inspect part completeness to step on W/O

0.00

150

*AS
15
0-89
B-116*

20

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84163

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May-07-12 8:42:35 AM

Item ID: D2873-045

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Nut Plate Assembly

Stop ***NS2***

Start Date: 07/05/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 21/05/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

20 20 1317

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

20x 13/01/17

180

Small Fab

0.00

180

Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 2-Identify as D2873-045

20x 13/01/17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84163

May-07-12 8:42:35 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 07/05/2012 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 21/05/2012 **Req'd Qty:** 40.00

40

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: **LG 52**

0.00

200

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

13/01/22

PLB-01-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-07-12 8:42:38 AM

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Work Order ID: 84163

84163

Parent Item: D2873-045

D2873-045

Parent Item Name: Nut Plate Assembly

Start Date: 07/05/2012

Required Date: 21/05/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21075L5

Purchased

No

100

Each

26.0000

2

80

MS21075L5

Nut Plate

**

Location

Loc Qty

Loc Code

ST304

26

121444

26

M6061T6B0.375X01.00

Purchased

No

180

f

13.3480

0.225

9.473684

0

M6061T6B0 375X01 000

6061T6 BAR .375 x 1.00

**

Location

Loc Qty

Loc Code

MAT001

2.292

118641

2.292

MAT002

11.056

120603

0.76

120866

0.76

121192

9.536

MS20426AD4-6

Purchased

No

180

Each

1,110.000

4

160

MS20426AD4-6

Rivet

**

Location

Loc Qty

Loc Code

ST317

1110

110139

187

118510

253

119436

670

EP 13/01/17
M123346
40x

9.473684 F.K 12/05/12
EP 13/01/17

M121708
80x

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 84163
Description: Radius Block		Part Number: D2873-5
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.500	✓		Fk-04	Vern.
1.000	+/-0.010	1.000	✓		"	"
0.750	+/-0.010	.748	✓		"	"
0.250	+/-0.010	.250	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
2.000	+/-0.010	2.000	✓		"	"
Ø0.128	+0.005/-0.001	.128	✓		"	"
0.359	+/-0.010	.359	✓		"	"
Ø0.316	+0.006/-0.001	.317	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
0.250	+/-0.010	.249	✓		"	"
0.061	+/-0.010	.060	✓		"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.229 x .125	✓		"	"

Measured by: Fk.	Audited by: ml	Prototype Approval: N/A
Date: 12/05/14	Date: 12/05/17	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	AK

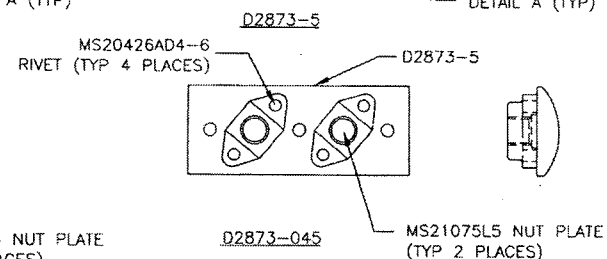
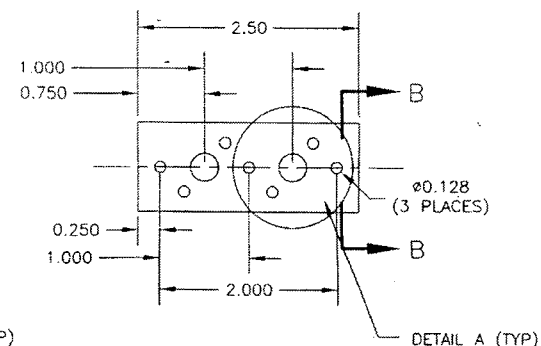
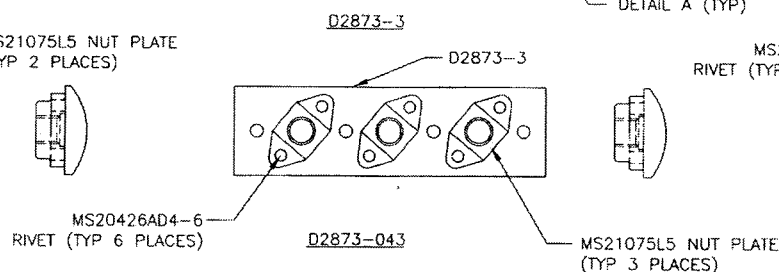
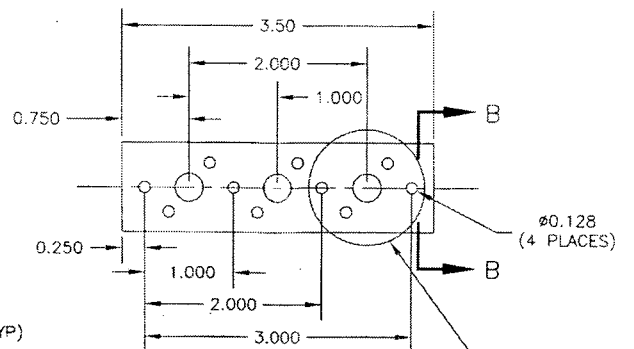
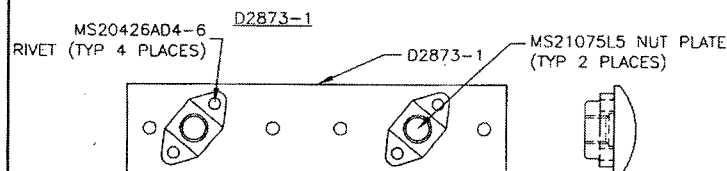
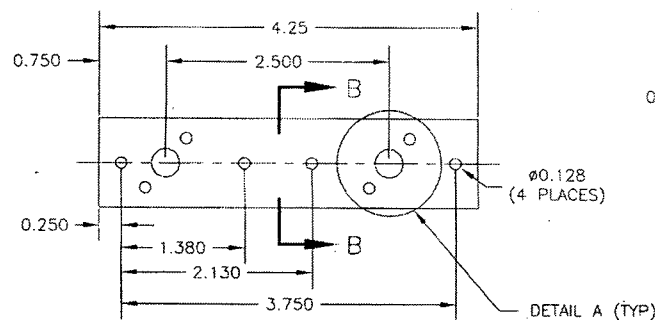
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2873-1/-3/-5 RADIUS BLOCK

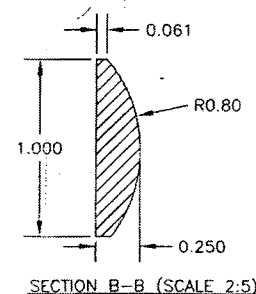
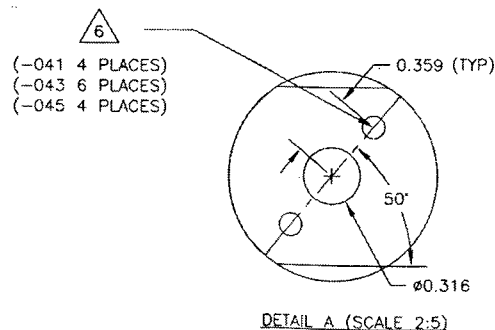
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED	PH	DART
DATE	05.07.26	05.07.26
		05.07.26

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84163 MLJ

12/05/07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	5/10/02							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries